Work Ord		25762 4 12:34:26 PM		*125	762*						Pag	ge 1
Item ID: Revision ID: Item Name:	D3459-3	ounting Plate		Accept	*N900	040	100)* ፡	Setup Sta	"11	S1*	.
Start Date: Required Date: Reference:	10/21/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:					· IVI		•
Approvals:	Process Pl QC:	an: MUS	Date: <u> \ - \ 0 - 7</u>	22 Tooling:		ate:		1	Run Sta Sta	art *N op *N	R1*	t t
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr D3459		vision Nbr v A										
Waterjet FLOW CNC Waterj		FLOW WATER JET Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	<u> </u>	0.00			-	_6	_0_		DAS 23 9-89	<u> </u>
110 *110* QC			LY ON DRILL PRESS	0.00 0.00	7"			_6_			DAS 23 9-89	14-11-14

Memo

Quality Control

DQA:			Date:												
						WORK ORDER NON-	-C(ONFO	RMANCE / UP	PDATE					AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
						DISPOSITION				AGAINST	DEP	PARTMENT	/PROCESS		
Work Orde	er: —				—	0						<u> </u>			1 —
Dout N	l a					Rework			Skid-tube	Crosstube	\dashv	0	Water Jet	-	Engineering
Part N	···· —					Scrap Use-as-is			Machining noforming	Small Fab	Н		d. Eng. Coor. e/Packaging		Quality Other
NCR I	do.					Suspected Unapproved		mem	Large Fab	Finishing Composite	_	Rec/Stor	Supplier	-	other
NCIVI	' '					Juspected Ollappioved			Large rab	Composite			Jupplier		
Root	$\neg \vdash$				Descr	ription of work order update	1	nitial	Acti	on		Sign &	-		
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verificatio	n	QC Inspector
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator														i	
Offset/Setup															
Process															
Supplier															
Training														ļ	
Transport														,	
Unapproved															
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Landi						General		l		ſ					1
	\vdash	ending				Bend		-	rogram			Outside Dim		\square	Pressure/Forced
	-		t Concer	ntric		BOM/Route		Grain			\dashv	Over/Under		Ш	Set-up
	—	racks				Broken/Damage/Defect		Hardwa			_	Part Incorrec		\square	Temperature/Cure
:		•	k/Ripple,	/Wave	-	Burrs			on Incomplete/Unc	· }		Part Lost/Mis	ssing	\square	Weld
	$\overline{}$	uffs				Contamination	-		ions Incomplete/Ur	nclear	—	Part Moved			Wrong Stock Pulled
	_	rushing			-	Countersink		_	ned/off center			Positioned W			
	_	eat Trea				Cut Too Short		Mislabe			f	Power Loss/S	Surge	Ш	Other
÷	—		Strip in	Tube	Щ	Drawing	_	Misread			_				
	-	1arks/Ch				Drill Holes		Off-set			_				
	_		equence		_	Finish	$\overline{}$		Calibration		_				
	L V	/ave/Twi	ist in Tub	e		Fit/Function		Out of S	equence						

Work Ord Wednesday, Oc		25762 4 12:34:26 PM		*125	5762*						Page 2
Item ID: Revision ID:	D3459-3	ouating Plate		Accept	*N900	040	100)*	Setup St		1.71
Item Name: Start Date: Required Date Reference:	10/21/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ! Customer:	ID:				- "N	IS2*
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_]			IR1*
PP -0 (Date:	SPC (Y/N):	D	ate:			St	op */	IR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
120		QC8- Inspect parts - seco	ond check	0.00				1			DAS
120 QC Quality Control		Memo		0.00				_6_			— 38 — 9-69 NOV 1 4 201
130		Identify as per dwg & St	ock Location: WAD	3 0.00				6./			ni list
130 Packaging Packaging		Memo *** STOCK	IN STEP CELL***	0.00				<u>bx</u>		— 	<u> h 19/</u> (

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140 QC

Quality Control

APU-(1-18

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RIVIAINCE / U		/ork Order up	odate only	AEROSPACE	
						DISPOSITION					EPARTMENT			
Work Orde	er: _						.			AGAINST D		, 1 NOCE33	_	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	۰ ۱۵۰					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	۱o					Suspected Unapproved			Large Fab	Composite		Supplier		
Root		;			Desci	ription of work order update	1	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Design														
Doc/Data												•		
Equip/Tooling														
Handling/Pre														
Material														
Operator													·	
Offset/Setup														
Process														
Supplier														
Training	Ш													
Transport		·												
Unapproved														
							FAL	ULT CAT	EGORY					
Landi	ng G	ear				General		,			-		_	
	E	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced	
	\Box	Centre No	t Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
	\Box	Cracks				Broken/Damage/Defect		Hardwa	re	Ĺ	Part Incorred	t	Temperature/Cure	
	\Box	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld	
	\Box	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled	
	\square	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_	
	H	Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other	
	l¹	nspection	Strip in	Tube		Drawing	Ш	Misread						
	lr	Marks/Ch	atter			Drill Holes		Off-set						
	1	Turning Se	equence			Finish		Out of C	Calibration					
		Nave/Tw	ist in Tub	e		Fit/Function		Out of S	equence					

Picklist Print

Wednesday, October 22, 2014 12:34:26 PM

Work Order ID: 125762

125762

D3459-3 Parent Item:

D3459-3

Parent Item Name:

Float Step Mounting Plate

Start Date: 10/21/14

Required Date: 10/21/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev: A

New Issue 06-01-06 JLM

IPP Rev: B waterjet 06-12-06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00		Purchased	No			110	f	53.0168	0.347	3			DAS 23
M6061T6	RO 187	X04 00	1 0						**				9-89 14

6061-T6 Bar .187 x 4.00

<u>Lo</u>	<u>cation</u>	Loc Oty	Loc Code	
MA	AT051	53.016842		
	m128265	16.116842		128265
	m129411	36.9		<u></u>

DQA:			Date:			WORK ORDER NON	TRAC						
QA Closed:			Date:			WORK ORDER NON	-C(ONFOI	RIMANCE /		Vork Order u	odate only	A E R O S P A C E
						DISPOSITION					EPARTMENT		<u>.</u>
Work Orde	er:					2131 33111314		1		Adalitati	—	/ FROCE33	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No					Scrap		I .	Machining	Small Fab	┥	d. Eng. Coor.	Quality
NICO N	مام					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	NO					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling						_							
Handling/Pre						•					ľ		
Material													
Operator	Ш												
Offset/Setup	Ш												
Process													
Supplier													
Training													
Transport			1										•
Unapproved													
							FAL	JLT CAT	EGORY				
Landir	ng Gea	ar				General							
	Ве	ending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Ce	entre No	t Concen	itric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cr	acks				Broken/Damage/Defect		Hardwa	re		Part Incorred	rt	Temperature/Cure
	Cr	imp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/l	Unqualified	Part Lost/Mi	ssing	Weld
	Cı	ıffs				Contamination		Instructi	ions Incomplete	/Unclear	Part Moved		Wrong Stock Pulled
	Cr	ushing				Countersink		Misalig	ned/off center		Positioned W	/rong	
Į	Щн€	eat Treat	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	In	spection	Strip in	Tube		Drawing		Misread	l	_			
	Шм	arks/Cha	atter			Drill Holes		Off-set					
	Tu	irning Se	quence			Finish		Out of C	Calibration				
	w	ave/Twi	st in Tub	e		Fit/Function		Out of S	equence				

DART AEROSPACE LTD	Work Order:	125762
Description: Float Step Mounting Plate	Part Number:	D3459-3
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.259	_		U	
2.715	+/-0.010	2.715"	_		v	Themas
0.403	+/-0.010	0.403			v	
R0.125	+/-0.010	0.125	_		26	
R0.063	+/-0.010	0.063	-		26	
0.839	+/-0.010	0.839"	_		ν	
0.188	+/-0.010	0.197	_		V	
					-	
						
	- DAS					

	UMS				
Measured by:	23 9-89	Audited by:	38	Prototype Approval:	N/A
Date:	14-11-14	Date:	NOV 9-89 1 4 2014	Date:	N/A

Rev	Date	Change	Revised by	Annuared
A	07.01.17	New Issue	KJ/JLM	Approved
В	07.09.06	Dimensions added	KJ/JLM	13
			NO/JEIN GA	Œ

